

Date: Monday, 12/01/2009 2:29:57 PM
 User: Julie Dawson

Black
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: STRUT		
Job Number	: 44552				Part Number	: D28105		
Estimate Number	: 11044				Drawing Number	: D2810 / D2727		
P.O. Number	:				Project Number	: N/A		
This Issue	: 12/01/2009 S.O. No. : <i>Sm/Fab</i>				Drawing Revision	: C / A1		
Prsht Rev.	: NC				Material	:		
First Issue	: / / Type : MACHINED PARTS				Due Date	: 20/01/2009 Qty: 10 Um: Each		
Previous Run	: 41676							
Written By	:							
Checked & Approved By	: <i>JUL 09.01.12</i>							
Comment	: Est. A 04.11.30 New issue KJ/JLM							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
		 Comment: Qty.: 2.1000 f(s)/Unit Total : 21.0000 f(s) 31.5 304 RD Tube .500 x .035W Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 Batch: <i>M110113</i>
2.0	BRAKE NC	NC BRAKE
		 Comment: NC BRAKE 1-Length as per Dwg D2810 and spec control Dwg D2727 using Jig DT8012 2-Deburr <i>M-1 09/02/19 (15X)</i> → SB 09/02/19 15
3.0	QC5	INSPECT WORK TO CURRENT STEP
		 Comment: INSPECT WORK TO CURRENT STEP
4.0	POWDER COATING	POWDER COATING
		 <i>M105642</i>

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: *8:30AM*OVEN TEMPERATURE: *320°F*FINISH TIME: *9:00AM*
9/02/2009 10:00AM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 44552

Part Number: D28105

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(15)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 09/02/20

6.0 PACKAGING 1

PACKAGING RESOURCE #1



(15)

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 365

9/2/20

SO

7.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/23 FD

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

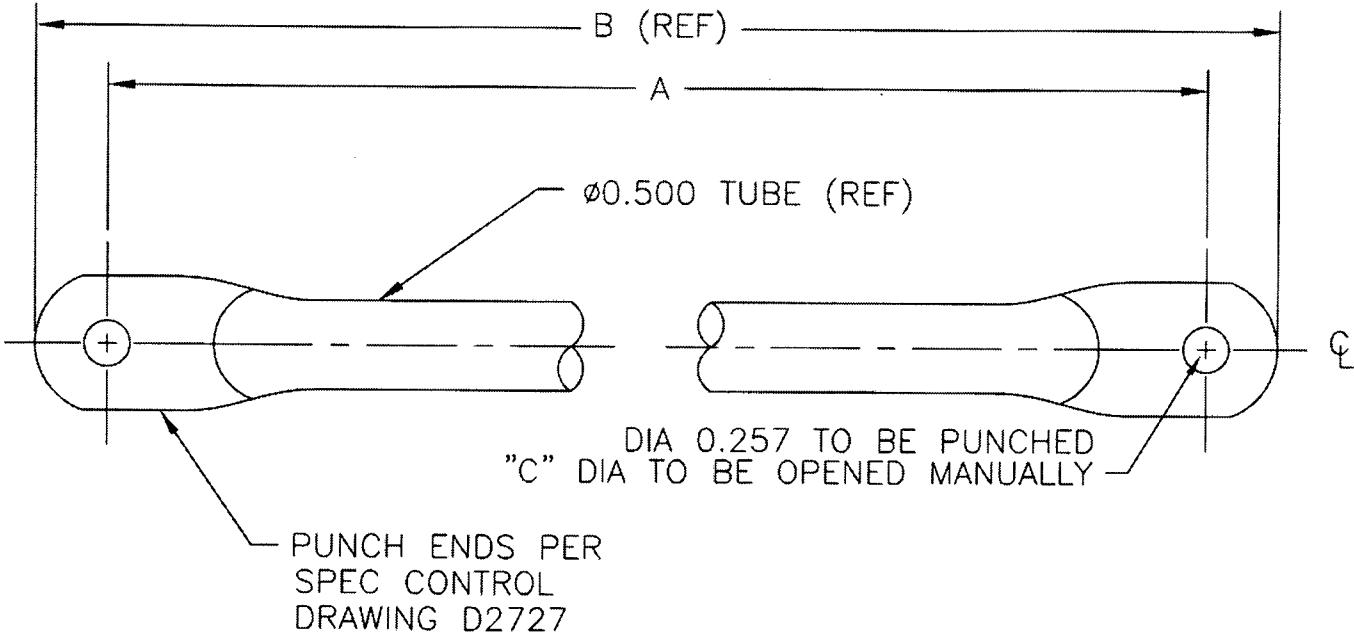
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2810 REV. C SHEET 1 OF 1
DATE		TITLE STRUT
04.11.22		SCALE NTS
A	00.11.08	NEW ISSUE
B	03.09.11	ADD FINISH
C	04.11.22	ADD -5

RELEASED

05-13-04



PART #	A	B	C
D2810-1	25.33	26.13	N/A
D2810-3	24.60	25.40	N/A
D2810-5	23.01	23.81	0.266

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D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.500 \times 0.035$ WALL (M304TR0.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

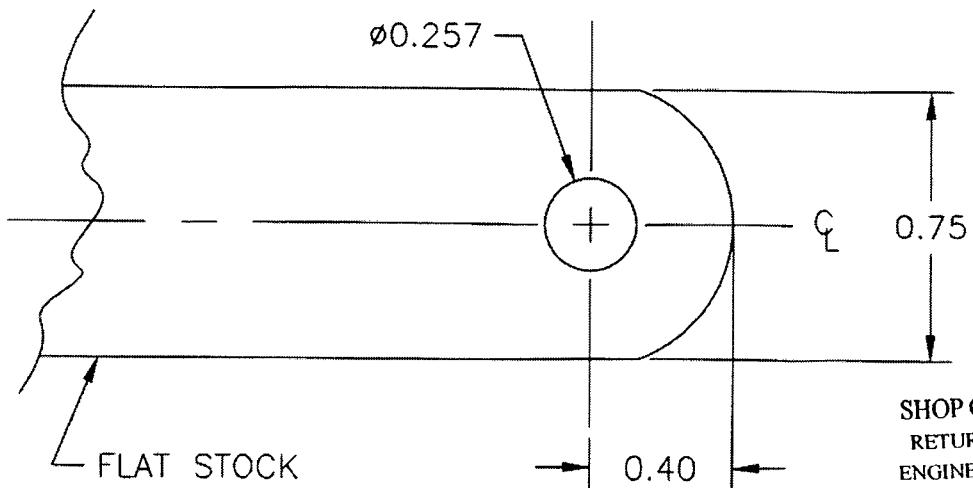
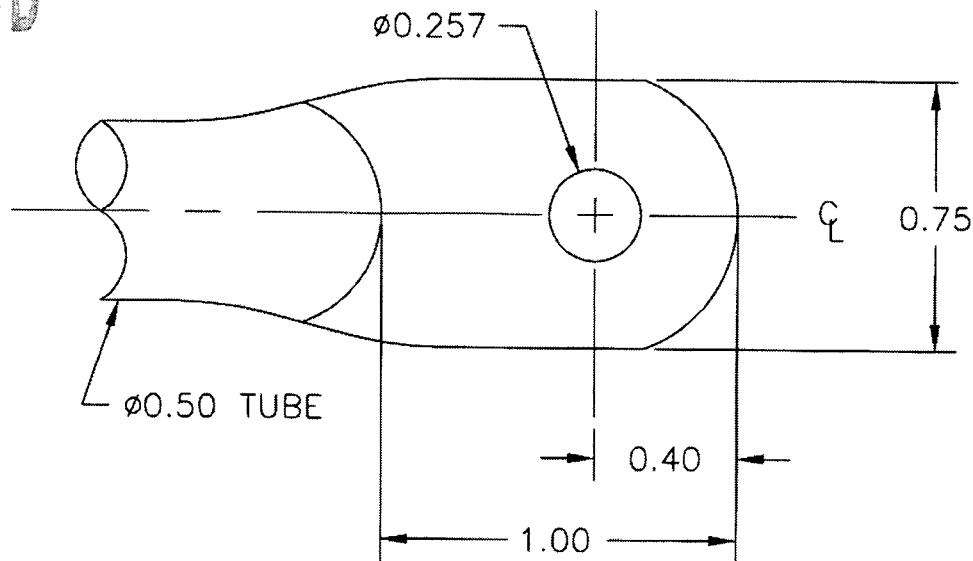
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
<i>DMY</i>	<i>GA</i>	D2727	SHEET 1 OF 1
DATE		TITLE	SCALE
97.11.24		PUNCH DT8012 SPEC CONTROL	2:1
A	97.11.24	NEW ISSUE	
A1	<i>HIP</i> 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE

NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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